

Work Order ID 85649-2

June-13-12 7:34:04 AM

85649

Ship tomorrow
Page 1

Item ID: DSI 9613-011

Revision ID: PRELIM

Item Name: Cargo Door Hinge Modification

Start Date: 6/13/12 Start Qty: 2.00

Required Date: 6/13/12 Req'd Qty: 2.00

Reference:

Approvals: Process Plan:

QC:

Date:

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Run Start *NR1*

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Accept Reject Reject Insp.
Code Qty Qty Number Stamp

Draw Nbr

Revision Nbr

DSI 9613

PA1

100

100

DC

Document Control

DOCUMENT CONTROL

Memo

Photocopy bluefile & type labels per PPP DSI9613-011 CHG001

0.00

0.00

110

110

Packaging

Packaging

Pick Kit

Memo

0.00

0.00

120

120

QC

Quality Control

QC4- 100% Inspect kits for completeness

Memo

0.00

0.00

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Customer:

Grmms 12-6-14
(7)

12/6/14

(+5)

Work Order ID 85649

June-13-12 7:34:04 AM

85649

Page 2

Item ID: DSI 9613-011
Revision ID: PRELIM
Item Name: Cargo Door Hinge Modification

Accept

N9000040100

Setup Start ***NS1***

Stop ***NS2***

Start Date: 6/13/12 Start Qty: 2.00 ***2***

Required Date: 6/13/12 Req'd Qty: 2.00 ***2***

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan:
QC:

Date:

Tooling:

Date:

Run Start ***NR1***

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
---------	--------	-----------	------------	------------	---------------	-------------

130

130

Packaging

Packaging

Packaging

Memo

Identify and pack for shipping as per PPP DSI9613-011

Location: 80

Rev

0.00

0.00

50

06/18/12

140

140

QC

Quality Control

QC21- Final Inspection - Work Order Release

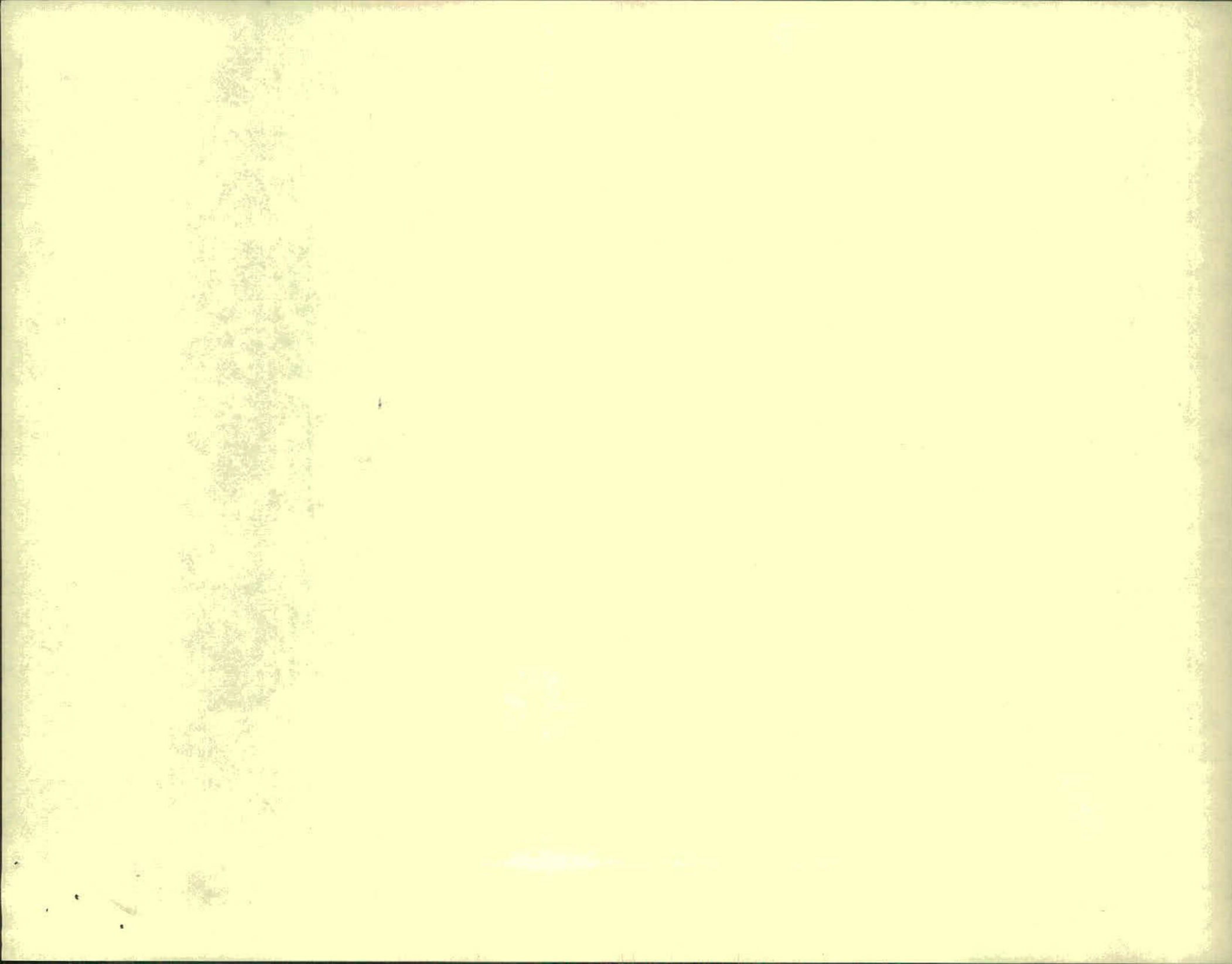
Memo

0.00

0.00

12/6/19

12/20/19



Picklist Print

June-13-12 7:34:03 AM

Page 1

Work Order ID: 85649

Parent Item: DSI 9613-011

Parent Item Name: Cargo Door Hinge Modification

Start Date: 6/13/12

Required Date: 6/13/12

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A 12.05.22 NEW ISSUE DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D4632-1 Striker Plate		Manufactured	No			110	Each	0.0000	1	2.7	85650		
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D4632-2 Striker Plate		Manufactured	No			110	Each	0.0000	1	2.7	85651		
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MS24694-S47 Screw		Purchased	No			110	Each	72.0000	8	16.50			
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Location	Loc Qty	Loc Code
----------	---------	----------

ST289	72	
-------	----	--

115622	72	
--------	----	--

MS27039-08-07 Screw		Purchased	No			110	Each	135.0000	8	16.50			
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Location	Loc Qty	Loc Code
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Mezz	135	
------	-----	--

4969	135	
------	-----	--

NAS1149DN832J WASHER		Purchased	No			110	Each	637.0000	8	16	6/13/12		
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Location	Loc Qty	Loc Code
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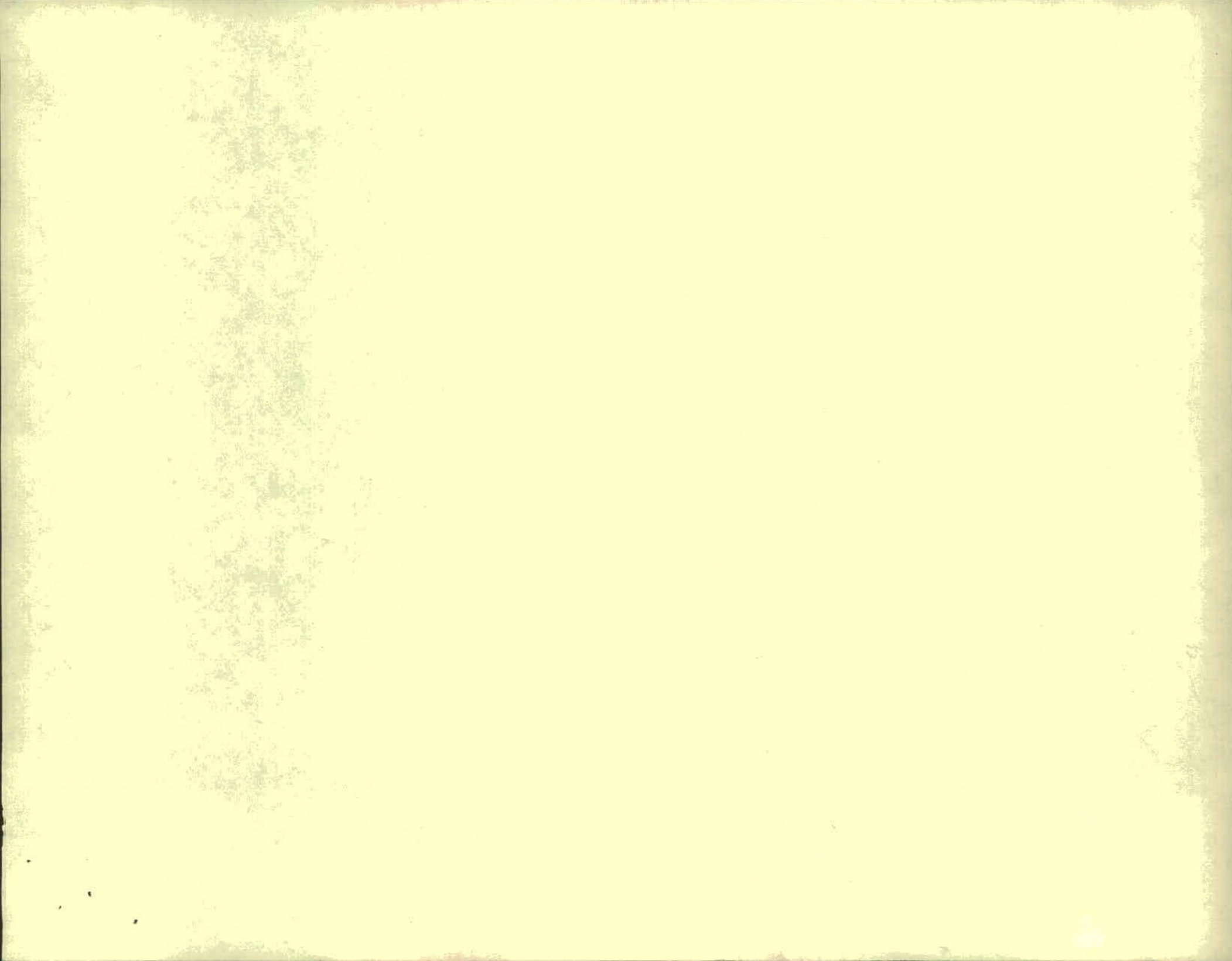
ST298	637	
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116513	16	
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119717	41	
--------	----	--

120422	580	
--------	-----	--

42



Picklist Print

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Page 2

Work Order ID: 85649

Parent Item: DSI 9613-011

Parent Item Name: Cargo Door Hinge Modification

Start Date: 6/13/12

Required Date: 6/13/12

Start Qty: 2.00

Required Qty: 2.00

NAS1149D0332J

Washer

Purchased

No

110

Each

2,197.0000

8

16 *SK*

SK

Location

Loc Qty

Loc Code

ST297

1000

121708

1000

ST298

1197

105793

12

110985

4

117087

89

119042

16

119717

306

120644

7

121011

763

SK

MS210421.08

Nut

Purchased

No

110

Each

167.0000

8

16 *SK*

SK

Location

Loc Qty

Loc Code

ST300

167

121524

167

MS210421.3

Nut

Purchased

No

110

Each

1,912.0000

8

16 *SK*

SK

Location

Loc Qty

Loc Code

ST300

1912

115835

4

117885

32

119017

884

119075

138

121349

71

121444

783

SK

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Shop Packet Print

Page 2

DART SERVICE INSTRUCTION

TO AMEND IIN-D139-799 REV. F AND ICA-D139-799 REV. 5

REF. FAA STC: SR02138SE
REF EASA STC EASA.10038656

PURPOSE

The purpose of this DSI is to clarify the installation of the D139-799-013 Cargo Door Fwd Opening Kit on aircraft that are equipped with 3P5230A01033 (LH) and 3P5230A01133 (RH) Cargo Doors with two gas springs (see Figure 3b of IIN-D139-799 Rev. F).

PROCEDURE

Amend IIN-D139-799 Rev.F steps as follows:

- 3.2.1.2 Remove left/right hinges from the doors as shown in Figure 3a including the door open switches on the fwd hinge bracket. Remove left/right gas spring hinges (if installed) from the door as shown in Figure 3b. On aircraft equipped with 3P5230A01033 (LH) and 3P5230A01133 (RH) Cargo Doors, remove 3P5230A15631 and 3P5230A15731 hinge brackets from the airframe as shown in Figure 1 of this DSI.
- 3.2.2.10 Install the D4074-7 Striker Plate using 4 x CR3523-4 rivet as shown in Figure 5c Section G-G. On aircraft equipped with 3P5230A01033 (LH) and 3P5230A01133 (RH) Cargo Door, trim Doorframe Channel as shown in Figure 2 of this DSI to allow space for alternate D4632-1 (LH) and D4632-2 (RH) striker plates. Install alternate D4632-1/-2 striker plate at the aft airframe hinge bracket location (see Figure 2 of this DSI). Transfer drill 4 x holes from 3P5340A31951 doubler to striker plate, and install using MS24694-S47 screw, NAS1149D0332J washer and MS21042L3 nut in 4 places.
- 3.2.2.11 Install D4074-1/-5 Bracket/Backing Plate using the existing holes in the cargo door as shown in Figure 5b Detail E. Plug holes at center of the door used for original gas springs using existing hardware. Torque screws per Table 1. On aircraft equipped with 3P5230A01033 (LH) and 3P5230A01133 (RH) Cargo Door, plug existing holes with Hysol EA934NA. Locate D4074-1 bracket at bottom of existing recess and transfer hole locations to door as shown in Figure 4 of this DSI. Install D4074-1/-5 brackets using hardware shown in Figure 5b Detail E of IIN-D139-799 Rev. F.
- 3.2.2.12 Install D4074-3 Channel using existing hardware in original gas spring cut out as shown in Figure 5d Section I-I. On aircraft equipped with 3P5230A01033 (LH) and 3P5230A01133 (RH) Cargo Doors, trim Doorframe Cover as shown in Figure 3 of this DSI to expose bottom side of Doorframe Channel. Locate D4074-3 Channel as shown in Figure 3 of this DSI and transfer 4 x $\varnothing 0.173$ " (#17 drill) from the D4074-3 Channel to the Doorframe Channel. Install D4074-3 Channel using MS27039-0807 screw, NAS1149DN832J washer and MS21042L08 nut in 4 places.

PART LIST

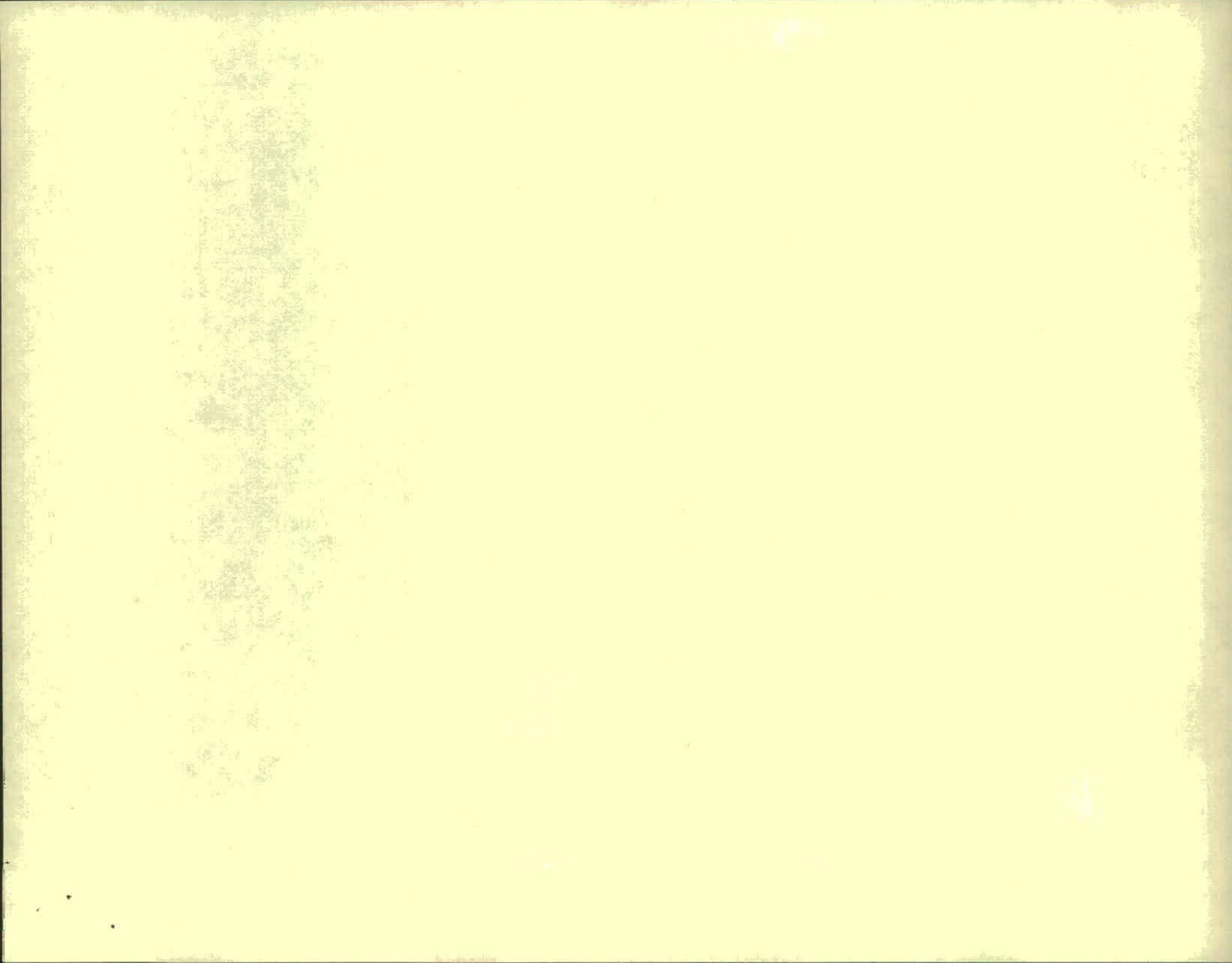
Note: The following parts are included in D139-799-013 at CHG 005 and later. For customers who already have D139-799-013 at CHG 004 and earlier, procure the DSI 9613-011 kit from Dart.

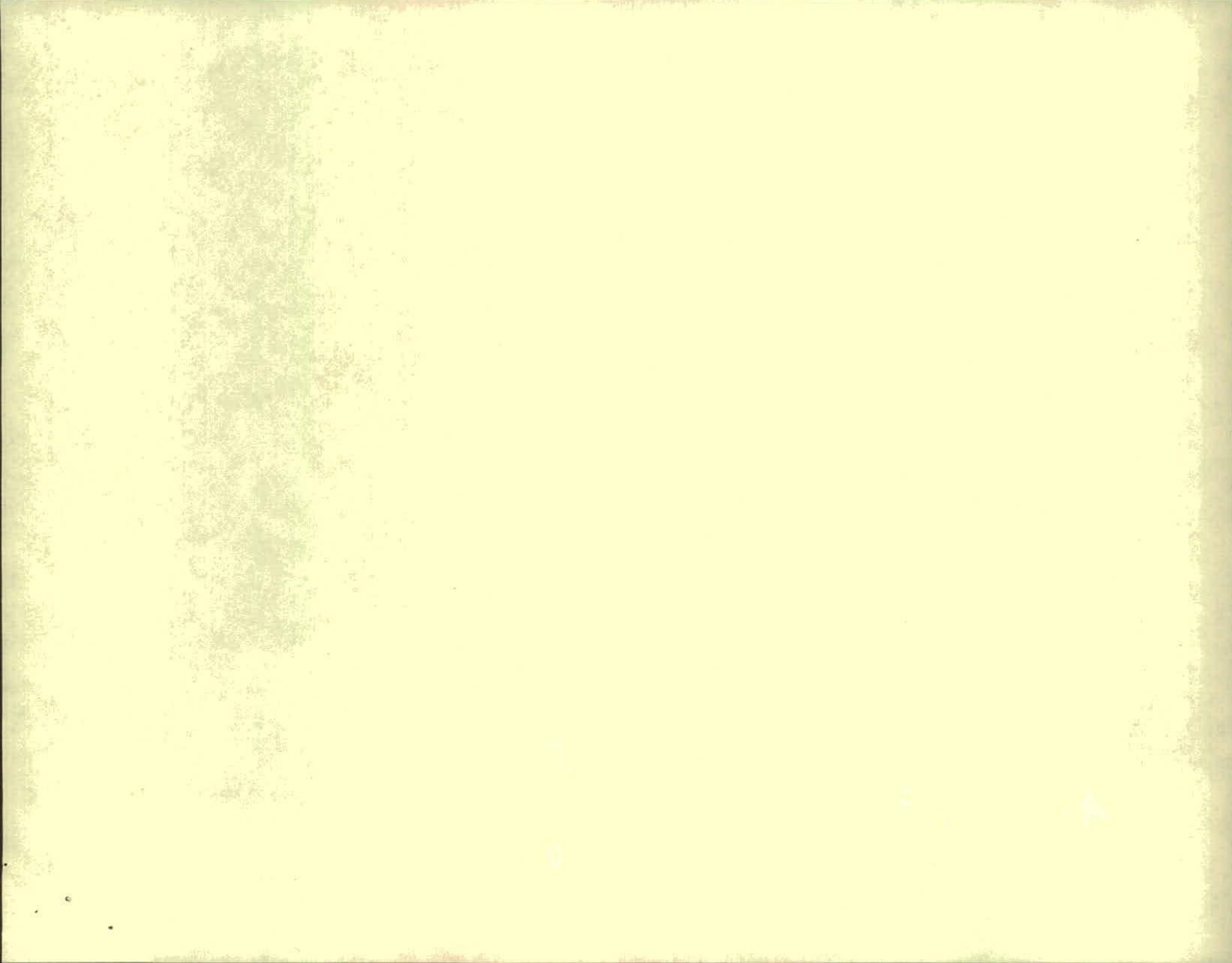
QTY. -011	PART NUMBER	DESCRIPTION
X	DSI 9613-011	CARGO DOOR HINGE MOD KIT
1	D4632-1	STRIKER PLATE
1	D4632-2	STRIKER PLATE
8	MS24694-S47	SCREW
8	MS27039-0807	SCREW
8	NAS1149DN832J	WASHER
8	NAS1149D0332J	WASHER
8	MS21042L08	NUT
8	MS21042L3	NUT

WEIGHT & BALANCE

This DSI has a negligible effect on Weight & Balance

A	NEW ISSUE	RF	12.05.29
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	KENT, WA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9613	SHEET 1 OF 5
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	CARGO DOOR HINGE MOD	NTS
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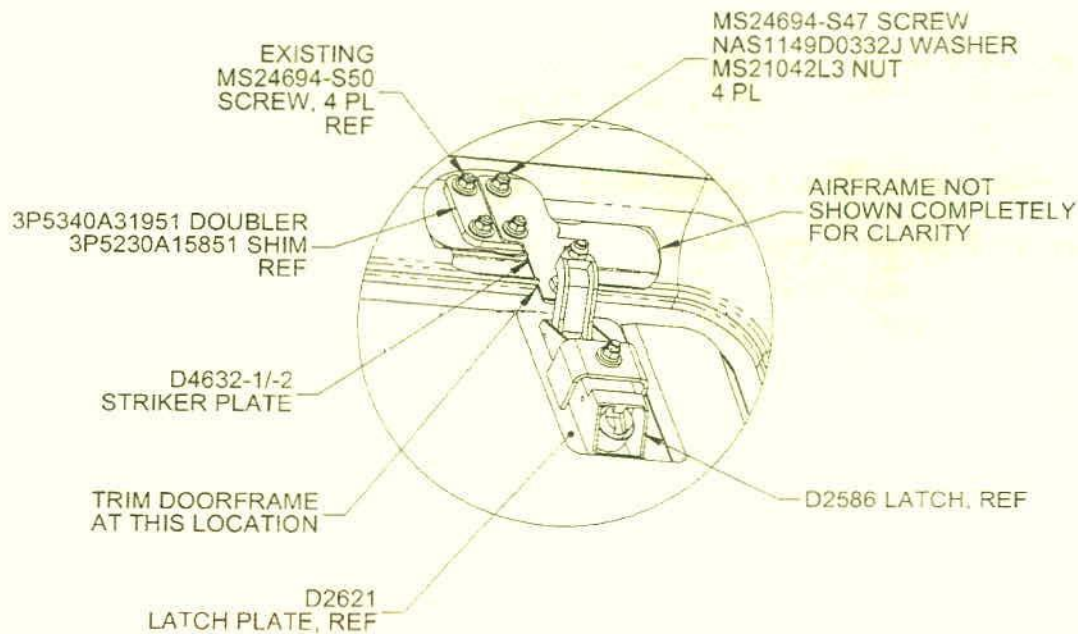
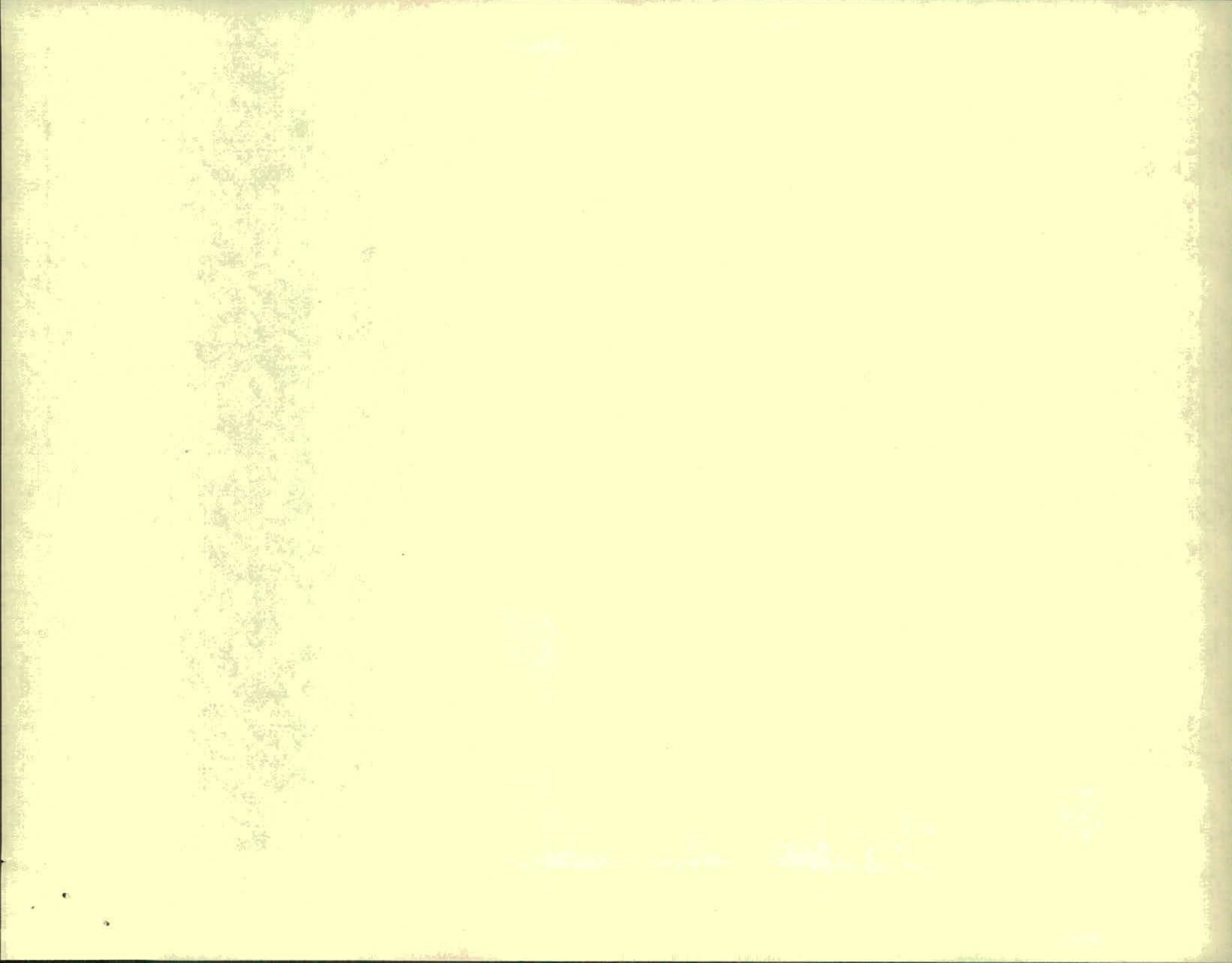


FIGURE 2 - D4632-1/-2 STRIKER PLATE INSTALLATION

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MFG. APPR.	N/A	DSI 9613	SHEET 3 OF 5
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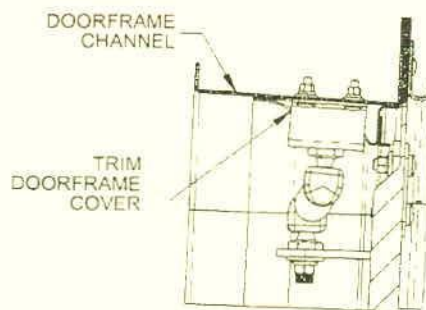
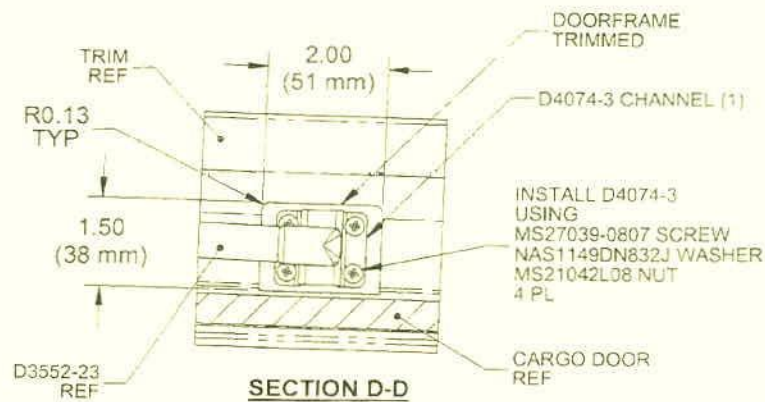
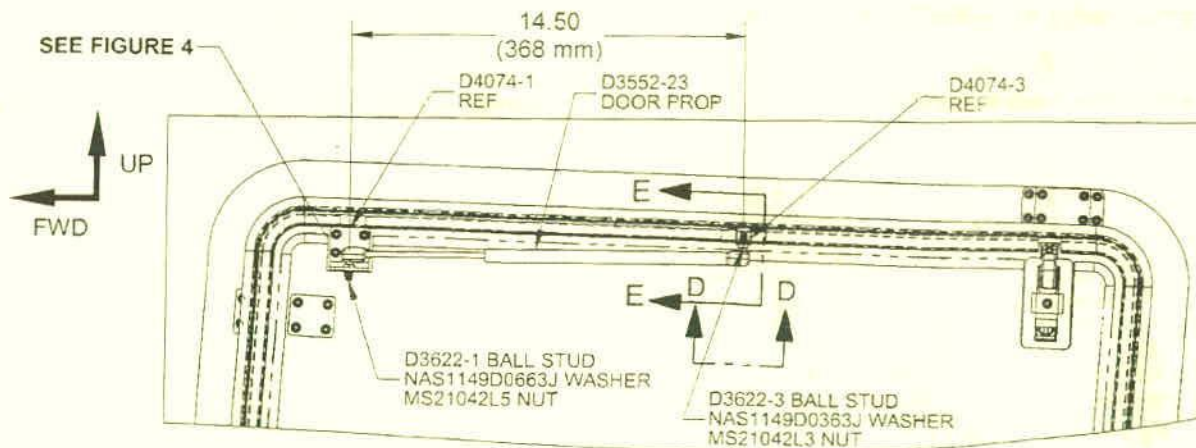


FIGURE 3 - D4074-3 CHANNEL INSTALLATION

DESIGN	RF	DART AEROSPACE USA, INC. KENT, WA	
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MFG. APPR.	N/A	DSI 9613	SHEET 4 OF 5
APPROVED	<i>[Signature]</i>	TITLE	SCALE
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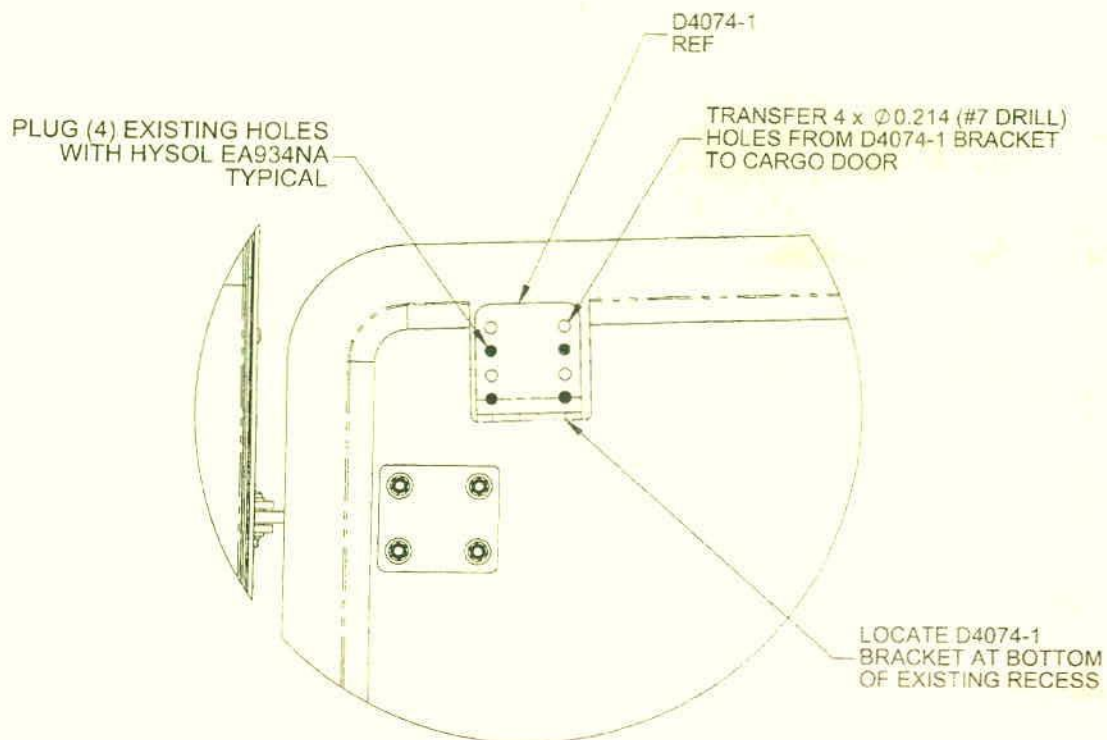


FIGURE 4 - D4074-1 BRACKET INSTALLATION

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DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO. DSI 9613	REV. A
MFG. APPR.	N/A		SHEET 5 OF 5
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	CARGO DOOR HINGE MOD	1:12
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